

# Work Order ID 72275

Wednesday, July 20, 2011 3:47:14 PM



Page 1

Item ID: D4004-11

Revision ID:

Item Name: Top Strap Attach Bracket

Start Date: 7/20/2011 Start Qty: ~~4.00~~ <sup>10</sup>

Required Date: 7/29/2011 Req'd Qty: 4.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan: R

Date: 7-07-20

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4004

A

100



Bandsaw

Jeaspa Bandsaw

BAND SAW

0.00

Memo

0.00

1-Cut D3033-144 extrusion to length per D4004-11 detail of dwg D4004

Ensure cut is started at correct place per dwg

Batch: 168524

2-Deburr

105



Small Fab

Small Fab

0.00

Memo

0.00

Drill and c'sink holes as per dwg and trim part to length as required.

(10)

Ac

11.08.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 72275**

Wednesday, July 20, 2011 3:47:15 PM

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Item ID: D4004-11

Accept

Revision ID:

Item Name: Top Strap Attach Bracket

Start Date: 7/20/2011 Start Qty: 4.00

Required Date: 7/29/2011 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Suloslos

(710)

Quality Control

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

10 6 Meluloslos

Hand Finishing

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Puff (10)

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 72275**

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Page 3

Item ID: D4004-11

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Revision ID:

Item Name: Top Strap Attach Bracket

Start Date: 7/20/2011 Start Qty: 4.00

Required Date: 7/29/2011 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start  
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140 Identify as per dwg & Stock Location: 103 0.00

Packaging

Memo

0.00

Packaging

150 QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

P 11/8/05 (10)

OK 11/08/05

P 11-08-5 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, July 20, 2011 3:47:21 PM

Page 1

Work Order ID: 72275



Parent Item: D4004-11



Parent Item Name: Top Strap Attach Bracket

Start Date: 7/20/2011

Required Date: 7/29/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev A 09.12.15 new issue EC verified by:DD  
10.05.17 as per ECN10-562 DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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40456-11-144

Purchased

No

100

f

0.0000

0.41

1.726316



SEAT TRACK

B68524

469/03  
5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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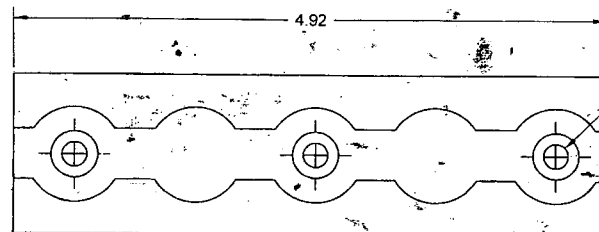


DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4004-11	JCA-M47-2-11

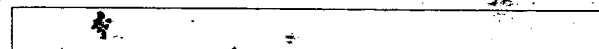
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK IN PROGRESS

NO. 72275

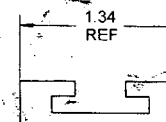
PL1107-20



DRILL  $\varnothing 0.204$  (#6 DRILL)  
CONCENTRIC WITH SEAT TRACK  
CSK.  $\varnothing 0.385 \times 100^\circ$   
3 PL



0.37  
REF



# **D4004-11 TOP STRAP ATTACH BRACKET**

RELEASED  
2010-05-05  
MM

## **NOTES:**

- 1) MATERIAL: MADE FROM ANCRA P/N 40456-11-144  
OR BROWNLINE P/N 20276-144-0-0  
OR D3033-144
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4004-11" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.14 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D4004</b>	REV. A
MFG. APPR.			SHEET 11 OF 11
APPROVED		TITLE <b>SIDE RESTRAINT</b>	SCALE
DE APPR.			NTS
DATE	10.02.10	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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